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		I FERROUS METAL PURE GAS Ar OR He	II ALUMINUM METAL PURE GAS Ar OR He	III FERROUS METAL MIXED GAS INCL CO ₂ , O ₂ , H ₂	IV SMAW OR FCWV FLUX VAPOR
		AMPS	AMPS	AMPS	AMPS
Spectra Orange	69	1300	750	550	450
Gray	56	225	125	100	75
Green	63	150	90	70	50
Yellow	100	80	50	35	30
Blue	44	40	25	20	15

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